

Date: Tuesday, 21/10/2008 8:16:14 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BLADE FOLD ASSY WELDMENT
Job Number :	42754		
Estimate Number :	13503		
P.O. Number :		Part Number :	PB674300109
This Issue :	21/10/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.6
First Issue :	//	Project Number :	N/A
Previous Run :	41363	Drawing Revision :	B1
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	28/10/2008
Written By :		Qty:	2
Checked & Approved By :	<u>MF 08-10-21</u>	Um:	Each
Comment :	Est Rev:A 08-06-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

Square Tubing

batch:- B41487MF 08-10-21

2.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Square Tubing

batch:- B41486 x 2MF 08-10-21

3.0	PB6743001201	Square Tubing
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Square Tubing

batch:- 41572 x 4MF 08-10-21

4.0	PB6743001203	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Square Tube

batch:- B41789 x 1, B40594 x 1MF 08-10-21

5.0	PB6743001239	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Square Tube

batch:- B41917 x 2, B41909 x 2MF 08-10-21

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Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 42754

Part Number: PB674300109

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PB6743001235	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Outer Tube

batch:- 41490

mf 08-10-21

7.0	PB6743001229	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Outer Tube

batch:- 341489

mf 08-10-21

8.0	PB6743001213	Flanged Hook
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Flanged Hook

batch:- 1040040 x 1/2

mf 08-10-21

9.0	PB6743001311	Restraint
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Restraint

batch:- B41211

mf 08-10-21

10.0	PB6743001277	Contoured Hinge Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Contoured Hinge Arm

batch:- B41499 x 2

mf 08-10-21

11.0	PB6743001243	Handle Arm Extension
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Handle Arm Extension

batch:- B24024 x 1, B40214 x 1

mf 08-10-21

12.0	D34409	Tube Detent Clip Base (Supersedes B67-43)
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Tube Detent Clip Base

batch:- B41205

mf 08-10-21

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 42754

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D344013

Bracket (Supersedes B67-43001-273)



Comment: Qty.: 1.0000 Each(s)/Unit To 2.0000 Each(s)

Bracket

batch:-

41452

CMF 08-10-21

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

** ensure no burn thru after welding in tube -235 and -229 only where bushing -265 ***

CK 08-10-27

SP 08-10-27

X2

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/10/28 (2)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/10/28 (X2)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

in detail D, mask in between -311 prior to paint

mask 1.750" on the end of -243 prior to paint

mask inside of D3440-9 prior to paint

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

11:25

OVEN TEMPERATURE:

320°

FINISH TIME:

11:55

M102316

FX 08/10/28

(2)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-P 08/10/28 (2x)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock





Location:

Carl.

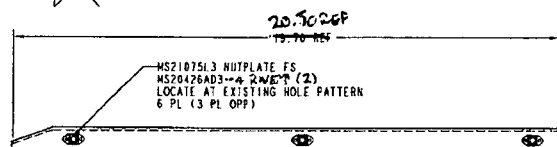
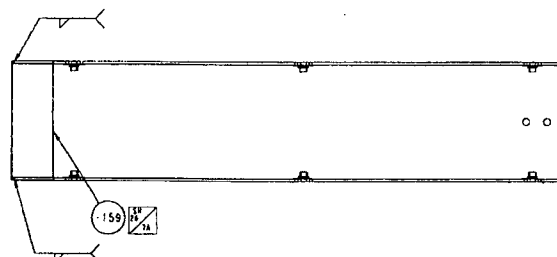
CMF 08-10-29

Date: Tuesday, 21/10/2008 8:16:14 AM
User: Melanie Fauteux

Process Sheet

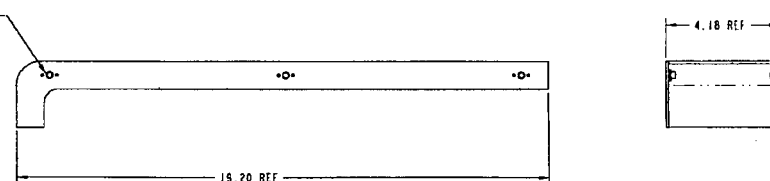
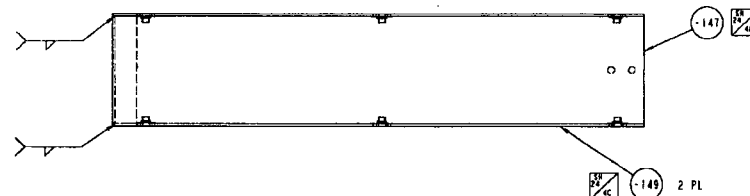
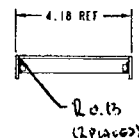
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT BLADE FOLD ASSY WELDMENT	
Job Number: 42754		Part Number: PB674300109	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
20.0	QC21	FINAL INSPECTION/W/O RELEASE	
			②
Comment: FINAL INSPECTION/W/O RELEASE		D 08/10/27	
Job Completion			MF 08-10-29

RELEASED
محرر ٢٠١٠



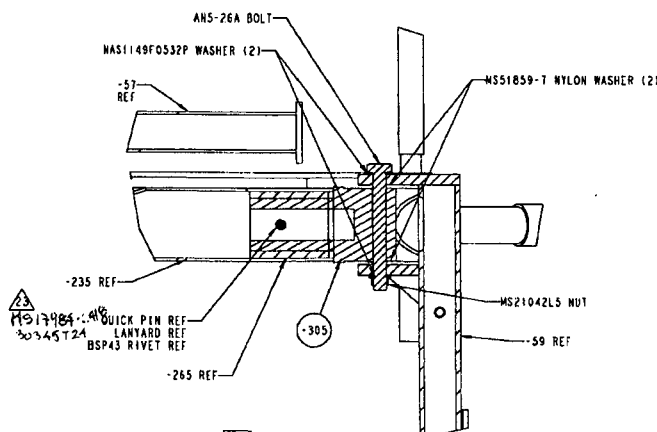
② -71 20 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



② -67 90 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



DETAIL A
SCALE 0.750
(-03 ASSY)

42754

PREMIER AVIATION, INC.
9800 Aviation Parkway, Grand Prairie, Texas 75050
DATE CODE PART NO. REV.
D105UV8 B67-43001 B1
SCALE: 1/8"=1" SHEET 9 OF 45

ORIGINAL

